



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2053**Job Sheet 183851****Part No:** D2053**Job Qty:** 10 ea**Part Name:** Bracket**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/27/18**Job Tracking No:****Due Date:** 10/5/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:**

Note: DWG REV C IPP D 02.03.18 Added Rev.B NG (Issue this IPP with part number D2052) IPP Rev:E now water jet 07-10-25 DD IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	10 pcs	10/5/18	10/5/18	0.00	0.31	Waterjet 1		SC 18/10/01
110	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Waterjet-1		SC 18/10/01
120	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC8-1		38
130	Brake NC	10 pcs	10/5/18	10/5/18	0.00	0.18	Brake NC 2		9-89 JAS
140	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC5		38
150	HandFinish	10 pcs	10/5/18	10/5/18	0.00	0.15	HandFinish1		BEB 18-0-22
160	Powdercoat	10 pcs	10/5/18	10/5/18	0.00	0.12	Powdercoat4		BEB 18-0-22
170	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC3		OCT 23 2018 68
180	Packaging	10 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-1	STOOL	OCT 26 2018 89
190	QC21-SA	10 Ea	10/5/18	10/5/18	0.00	0.00	QC21		21 OCT 29 2018

Part Op 100 - 1-Cut as per Dwg D2053 Dwg Rev: C Prog Rev: C ****grain direction along 1987**** 2-Debur if Descriptions: necessary

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D2053 using CNC Brake

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - START TIME: 8:30 OVEN TEMPERATURE: 320° FINISH TIME: 9:00

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

M138839.**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.090	5052-H32 .090 Sheet	.4000 sf (.04 ea)	100-Waterjet	M131392

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M5052H32S.090	0	49	0

DAK
AEROSPACE

Container No: S114998



Part: D2053

Job No: 183851

Serial No/Batch: S114998

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

1250 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/01/18

Part Specifications
Specifications could not be found.

Plex 9/27/18 2:10 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order: 183851
Description: Bracket		Part Number: D2053
Inspection Dwg: D2053	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0,099	1		VSZ-01	
0.400	+/-0.010	0,404	1			
1.09	+/-0.030	1,10	1			
0.719	+/-0.010	0,720	1			
1.987	+/-0.010	1,986	1			
1.00	+/-0.030	1,009	1			
Ø0.635	+0.008/-0.001	0,636	1			
2.800	+/-0.010	2,796	1			
0.090	+/-0.010	0,090	1			

Measured by: SC Date: 18/10/01	Audited by: 38 Date: OCT 02 2018	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	09.06.01	New Issue	KJ	MA

1884

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